

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁵ : A46B 9/04, B29C 45/14		A1	(11) International Publication Number: WO 94/05183
(21) International Application Number: PCT/NO93/00132		(43) International Publication Date: 17 March 1994 (17.03.94)	
(22) International Filing Date: 1 September 1993 (01.09.93)		(74) Agent: LANGFELDT, Jens, F., C.; Bryns Patentkontor A/S, P.O. Box 765, Sentrum, N-0106 Oslo (NO).	
(30) Priority data: P 42 29 152.6 1 September 1992 (01.09.92) DE		(81) Designated States: AT, AU, BB, BG, BR, BY, CA, CH, CZ, DE, DK, ES, FI, GB, HU, JP, KP, KR, KZ, LK, LU, MG, MN, MW, NL, NO, NZ, PL, PT, RO, RU, SD, SE, SK, UA, US, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).	
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(54) Title: TOOTHBRUSH AND METHOD FOR MAKING SUCH TOOTHBRUSH			
(57) Abstract			
<p>In making a toothbrush of the type having a shaft-like handle (3), a neck section (4) joining said handle and a headpiece (5) for toothbrush bristles (6), said body is made of a first plastic material through an injection moulding step. In order to provide said body with two or more portions (20, 21, 22) made of a second material, e.g., elastic and/or non-slip material such as rubber-like material, or a material having a colour different from that of the first material, the toothbrush body is provided with recess sections (17, 18, 19). Said second material is supplied through a plurality of channels (29, 30, 31, 32) into injection nozzle means (33, 34, 35) to provide injection of said second material in a single step, multi-point injection process into said recesses on said body to form said portions (20, 21, 22), said recesses (17, 18, 19) and said portions (20, 21, 22) thus being physically isolated from each other by said first material.</p>			

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TOOTHBUSH AND METHOD FOR MAKING SUCH TOOTHBUSH

The invention relates to a toothbrush with a toothbrush body, comprising a shaft-like handle, a neck section joining said handle and headpiece for toothbrush bristles, said body being made of a first plastic material through injection moulding, and said body being provided with two or more portions made of a second material, e.g. elastic and/or non slip material such as rubber-like material, or material having a colour different from that of said first material.

Further, the invention relates to a method for making a toothbrush of the type having a shaft-like handle, a neck-section joining said handle and headpiece for toothbrush bristles, said body being made of a first plastic material through an injection moulding step, and said body being provided with two or more portions made of a second material, e.g. elastic and/or non-slip material, or a material having a colour different from that of said first material, through a further injection moulding step.

Most of the various shapes of toothbrushes are already known. When used, the brush is rotated between the fingers holding it, according to the various positions for the dental areas to be cleaned, and then held securely for the cleaning process itself. Location of position essentially takes place at the front end of the handle in front of the neck section joining the head of the brush, as the toothbrush is held between the thumb and index fingers. This holding area customarily has shapings, possibly provided with a profiled portion, which favour advantageous holding of the brush only in a "preferred" position or possibly also in a position rotated 180 degrees to this. Intermediate positions require the hand or arm to be twisted, making it uncomfortable, however, to carry out the cleaning movement which is intended.

In the art, it is known to have a toothbrush with one or more non-slip portions applied to the toothbrush body. Such portions are provided by a single point injection moulding of elastic and/or non-slip material, e.g. rubber-like material, 5 to fill recesses on the toothbrush body, thus forming said portions. However, single point injection moulding implies that when having two or more areas or recesses to be filled in order to create such portions, there must be a material flow channel or channels available between such areas or 10 recesses on said body in order to enable said material to flow into said areas or recesses in such a single shot, single point injection moulding step. However, such channels will in most cases be aesthetically non-satisfactory, and more than often a matter of design trade-off. 15 Further, especially on toothbrush handles made of transparent material and in cases of desiring a more flexible approach in toothbrush design, such channels will in some cases cause the toothbrush body at the location of such channels, or adjacent thereto to be structurally weaker, in particular at the neck 20 region of the toothbrush body. In particular, if both the head and handle of the toothbrush are to have such elastic and/or non-slip material, the prior art method of using single point injection moulding of such material will result in a toothbrush having a structurally weakened neck because 25 of the material flow channels to be located in said neck.

To avoid said deficiencies related to both the toothbrush itself and the method for making such toothbrush, it is proposed for such toothbrush that said portions made of said 30 second material are physically spaced apart and isolated by means of said first material. Such toothbrush will have an aesthetically improved appearance, as well as being structurally stronger than any prior art toothbrush of such type.

In order to make such toothbrush with the said properties, it is proposed that the method, according to the invention,

provides that said second material is ejected through a single step, multi-point injection process into spaced apart recesses on said body to form said portions, said recesses being physically isolated from each other by said first material. Thereby, a single step injection moulding of said second material will be provided without the deficiencies of the prior art material flow channel or channels on said body.

Further, embodiments of the toothbrush and the method for making the toothbrush will appear from the attached patent claims as well as from the description below, with reference to the enclosed drawings.

The invention, together with its essential details, is explained below in greater detail with the aid of the enclosed drawings.

Fig. 1 shows a side view of a preferred embodiment of the toothbrush according to the invention.

Fig. 2 is a front view rotated 90 degrees in relation to the view of Fig. 1.

Fig. 3 is an enlarged cross section of the toothbrush at III-III of Fig. 2.

Fig. 4 shows a cross section through an injection moulding apparatus for carrying out a first injection step for making a toothbrush body of a first material.

Fig. 5 shows a device for multi-point injection moulding of a second material to fill out specific recesses on said toothbrush body.

Fig. 1 shows a toothbrush 1 with a toothbrush body 2, the longitudinal extension of which is divided into three sections 3, 4, 5. These sections comprise a shaft-like

handle 3, a necksection 4, as well as a headpiece 5 at the front end. The headpiece 5 has bristles 6 on its upper side.

5 In the further course of this description, the side of the brush body from which the bristles 6 project will be denoted as the front 7 and the opposite side as the rear 8 of the toothbrush.

10 As can be clearly seen from figures 1-3, the handle 3 has finger rest portions 9 with an essentially circumferential profiled section 10 at the front end. In the present example, this profiled section is formed by suitably elastic, circumferential rings 11 being mutually spaced in the longitudinal direction of the toothbrush. The finger rest portion 15 9 extends over an area which approximately corresponds to the length of a thumb resting at this area of the toothbrush and could in a typical example be approximately 2 cm long.

20 The rings 11 are located in ring shaped recesses extending around the handle cross sectional circumference and are provided through a second multi-point injection process following the making of the toothbrush body 2 made through a first injection moulding process. Said body is made of a first plastic material. Elastic and/or non-slip materials 25 could be used as the said second material, such material being mechanically softer than said first material of the toothbrush body, thus providing non-slip surfaces on the toothbrush body. Alternatively, said second material could be of the same type as said first material, but of different 30 colour than said first material.

Due to the said two-step injection processes, said second material will fit tightly into the recesses provided in said body 2.

Instead of annular continuous circumferential rings 11, such rings may also have interruptions along the circumference.

However, it is important in this regard that the profiled sections of the finger rest portions allow the toothbrush to be held virtually equally well in practically all positions of rotation of the toothbrush. This is also facilitated by 5 the shape of the cross section of the toothbrush body shown at III-III in figure 2 which, while preferably being rectangular or square with rounded corners, as shown in figure 3, may possibly be of circular cross section.

10 Said portions of the toothbrush made from said second material may have a different colour from the rest of the brush body, thus additionally distinguishing the said portions from the toothbrush body. In cases of the toothbrush body being made of a transparent material, such 15 differently coloured second material may provide a highly satisfactory aesthetic appearance of the overall toothbrush.

In the example of figure 2, the finger rest portion 9 is located at a part of the handle 3 which tapers towards the 20 neck section 4 of the toothbrush. As indicated by means of dotted lines, an ergonomic shaping of the finger rest portion 9 could, however, be provided, corresponding to the general shape of a thumb surface. This could be essentially 25 symmetrically circumferential or at least be provided on the front and the rear of the toothbrush body 2.

In addition to the profiled section 10 of the finger rest portion, it can be seen from the examples of figures 1 and 2 that there is a further profiled section 10a at the free end 30 region of the handle 3, said section particularly serving as a rest for the ball of the thumb. Like profiled section 10, that profiled section 10a also has circumferentially arranged rings 11, although in the present example only two such rings are provided. However, it should be noted that the number 35 and spacing of rings 11 as shown in figures 1 and 2 may vary both at the finger rest area 9 and at the free end region of the toothbrush.

For the sake of clarity, the cross section of the finger rest portion 9 shown in figure 3 in the section through a ring 11 has a comparatively large recess depth, which, however, in
5 practice could be a few tenths of a millimetre.

If necessary, the rings 11 can also be injected directly or almost directly onto the surface of the handle 3 at the area of the finger rests portion 9 which is provided.
10

In addition to said annular profiled sections 10 and 10a, surfaces 12 and 12a integral with said sections 10 and 10a, respectively, are provided in the example of figure 1 and 2 at the front 7 and at the rear 8 of the toothbrush, approximately at the area of the ring-like profiled sections 10 and 10a. These surfaces or members 12 may slightly project above the contour of the brush body 2, however being approximately flush with the profile height of the rings 11 or possibly extending slightly thereabove.
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As shown in the drawings, the annular profiled sections 10 and 10a can take the form of radial rings with the ring plane being approximately at right angles to the longitudinal axis of the brush body. On the other hand, it is also possible to provide such rings extending at an angle to the longitudinal axis of the brush body. Further, it is conceivable that approximately zig-zag disposed circumferential rings or profiled sections of the said type are provided on the brush body. As indicated by the portion 13 of figure 1, such portion could be provided with said second material in order to make at least the edges of the brush head softer.
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Thus, during the making of the toothbrush, it will be noted that the portions thereof including said second material are physically separated and isolated from each other with no material flow channel for the second material extending between such portions. Such interconnecting channel or
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channels between such regions to be provided with said second material would be undesirable, in particular on account of physical strength and also for aesthetical reasons, in particular in connection with a transparent form of brush body 2.

The invention is now to be further described with reference to figures 4 and 5 of the drawings.

In figure 4 there is shown an apparatus for making the toothbrush body 2 of the first material. In a conventional manner, two mould parts 14 and 15 are provided, said mould parts forming therebetween an injection cavity 16 to form the toothbrush body 2. As noted from figure 4, the head of the toothbrush has a recess 17 for receiving in a subsequent injection moulding step said second material. Similarly, the toothbrush body is to have slimmer sections 18 and 19 near the neck and the free end of the toothbrush, respectively. Said regions 17, 18 and 19 are intended for receiving said second material to form portions 20, 21 and 22, as to be further explained in connection with figure 5. In figure 4 said first material for making the toothbrush body 2 is supplied through a manifold 23 having a material flow channel 24. Said first material exits from said manifold through nozzle means 25 and into the cavity 16, in the example shown at the rear end of the body 2 to be made.

After the completion of the first injection moulding step for making the toothbrush body of said first material, said body is placed in a second mould constituted by mould parts 26 and 27 as shown in figure 5.

The apparatus has a manifold 28 with a material flow inlet 29 for said second material. The inlet 29 is branched off into outlet channels 30, 31 and 32. The material flow from channel 30 exits through a nozzle 33 into the region 17 of the toothbrush 2 (as shown in figure 4) to form said portion

20 on the toothbrush. Similarly the material flow from outlet channel 31 exits through a nozzle means 34 at region 18 of the toothbrush body 2 to form the portion 21 on the toothbrush. Finally, the material flow from outlet channel 5 32 exits through nozzle means 35 at region 19 of body 2 to 2form the region 22 on the toothbrush. Thus, in the injection moulding step as shown and described in connection with figure 5, multi-point injection moulding is used to create said portions 20, 21 and 22 in a single injection moulding step. As indicated above, and as further clearly seen from figure 5, there are no interconnecting material flow channels between the created portions 20, 21 and 22, thus providing the toothbrush with an aesthetically satisfactory appearance, while retaining the physical strength of 10 the overall toothbrush.

15 It will be readily understood that the examples illustrated in figures 1, 2 and 3 of the toothbrush, as well as the examples shown in figures 4 and 5 in connection with the method for making such toothbrush, may easily be modified 20 within the scope and the inventive concept of the present invention.

25 Thus, it will be readily understood that although the multi-point injection as demonstrated in figure 5 has three nozzle means for single step injection moulding, there could be provided, e.g., two nozzle means or four or more nozzle means with associated outlet channels in the manifold 28.

Patent claims

1.

5 A toothbrush with a toothbrush body comprising a shaft-like handle, a necksection joining said handle and head piece for toothbrush bristles, said body being made of a first plastic material through injection moulding, and said body being provided with two or more portions made of a second material, 10 e.g. elastic and/or non-slip material such as rubber-like material, or a material having a colour different from that of said first material, characterized in that said portions made of said second material are physically spaced apart and isolated by means of said first material.

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2.

A toothbrush according to claim 1, characterized in that said portions are provided on said handle and/or said neck section and/or said headpiece.

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3.

A toothbrush according to claim 2, characterized in that said handle has a finger rest portion with an essentially circumferential profiled section located at least at the neck section end of the toothbrush.

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4.

A toothbrush according to claim 2 or 3, characterized in that a circumferential hand rest portion is provided at the free end region of the handle, preferably at a distance from the end of the handle.

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5.

A toothbrush according to anyone of the claims 1-4, characterized in that said first material is transparent.

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6.

A toothbrush according to any one of the claims 1-5, characterized in that said body is provided at said portions with recesses filled with said second material.

7.

A toothbrush according to any one of the claims 1-6, characterized in that the extent of said finger rest portion in the longitudinal direction of the brush body is approximately equal to the width of a finger, preferably the thumb or the length of thumb contact.

8.

A toothbrush according to any one of the claims 1-7, characterized in that said portions are provided at least on the bristol side in addition to essentially circumferentially profiled section or sections at the neck section and of the handle and/or at the free end area of the handle.

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9.

A method for making a toothbrush of the type having a shaft-like handle, a neck section joining said handle and a headpiece for toothbrush bristles, said body being made of a first plastic material through an injection moulding step, and said body being provided with two or more portions made of a second material, e.g., elastic and/or non-slip material, or a material having a colour different from that of said first material, through a further injection moulding step, characterized in said second material being injected through a single step, multi-point injection process into spaced apart recesses on said body to form said portions, said recess being physically isolated from each other by said first material.

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10.

A method according to claim 9, characterized in that said multi-point injection provides application of said second material to said handle and/or said neck portion and/or said headpiece.

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AMENDED CLAIMS

[received by the International Bureau on 31 January 1994 (31.01.04); original claim 1 amended; other claims unchanged (3 pages)]

1.

A toothbrush with a toothbrush body comprising a shaft-like handle, a necksection joining said handle and head piece for
5 toothbrush bristles, said body being made of a first plastic material through injection moulding, and said body being provided with two or more portions made of a second material, e.g. elastic and/or non-slip material such as rubber-like material, or a material having a colour different from that
10 of said first material, characterized in that said portions made of said second material are physically spaced apart and isolated by means of said first material, said portions provided through a single step, multi-point injection process
15 into spaced apart recesses on said body defining said portions.

2.

A toothbrush according to claim 1, characterized in that said portions are provided on said handle and/or said neck section
20 and/or said headpiece.

3.

A toothbrush according to claim 2, characterized in that said handle has a finger rest portion with an essentially
25 circumferential profiled section located at least at the neck section end of the toothbrush.

4.

A toothbrush according to claim 2 or 3, characterized in that
30 a circumferential hand rest portion is provided at the free end region of the handle, preferably at a distance from the end of the handle.

5.

35 A toothbrush according to anyone of the claims 1-4, characterized in that said first material is transparent.

6.

A toothbrush according to any one of the claims 1-5, characterized in that said body is provided at said portions with recesses filled with said second material.

5

7.

A toothbrush according to any one of the claims 1-6, characterized in that the extent of said finger rest portion in the longitudinal direction of the brush body is approximately equal to the width of a finger, preferably the thumb or the length of thumb contact.

10 8.

A toothbrush according to any one of the claims 1-7, characterized in that said portions are provided at least on the bristol side in addition to essentially circumferentially profiled section or sections at the neck section and of the handle and/or at the free end area of the handle.

15 20 9.

A method for making a toothbrush of the type having a shaft-like handle, a neck section joining said handle and a headpiece for toothbrush bristles, said body being made of a first plastic material through an injection moulding step, and said body being provided with two or more portions made of a second material, e.g., elastic and/or non-slip material, or a material having a colour different from that of said first material, through a further injection moulding step, characterized in said second material being injected through a single step, multi-point injection process into spaced apart recesses on said body to form said portions, said recess being physically isolated from each other by said first material.

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10.

A method according to claim 9, characterized in that said multi-point injection provides application of said second material to said handle and/or said neck portion and/or said headpiece.

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1 / 2

Fig. 1

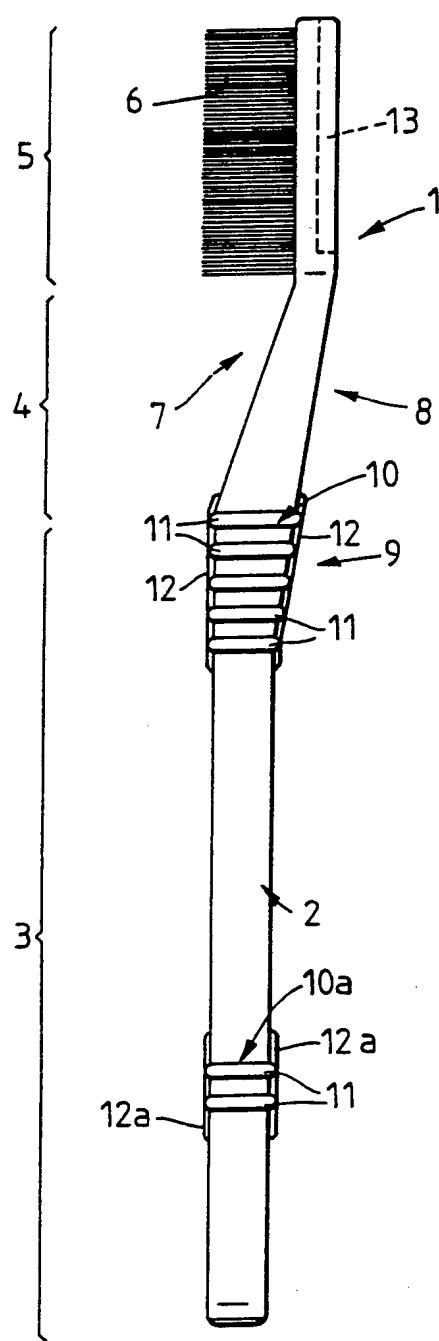


Fig. 2

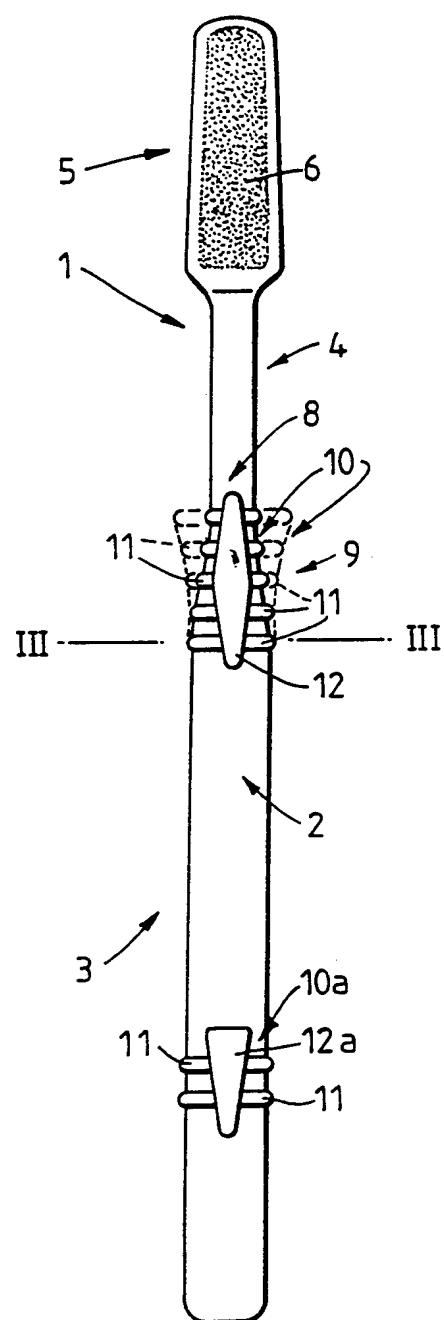
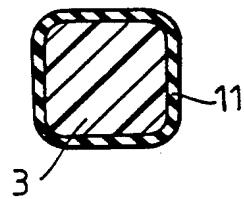
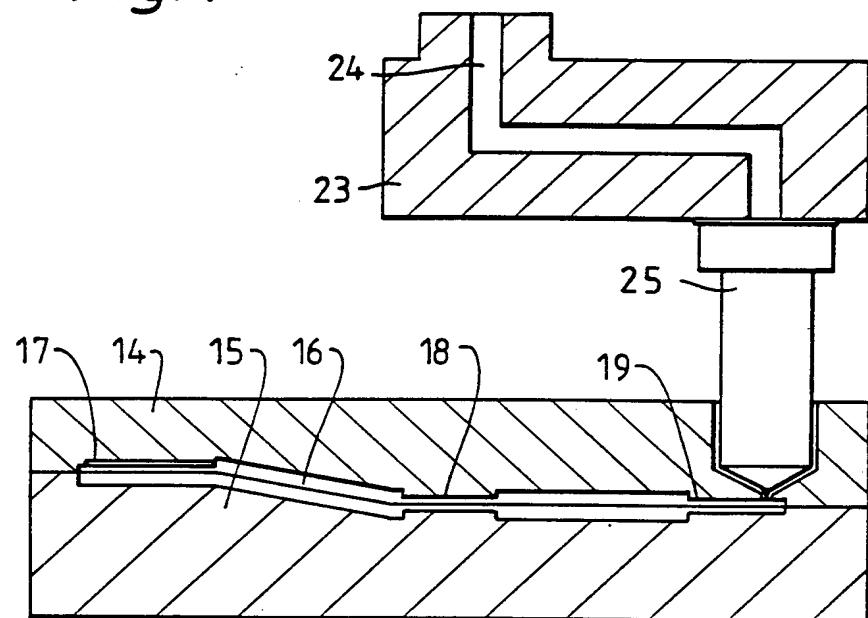
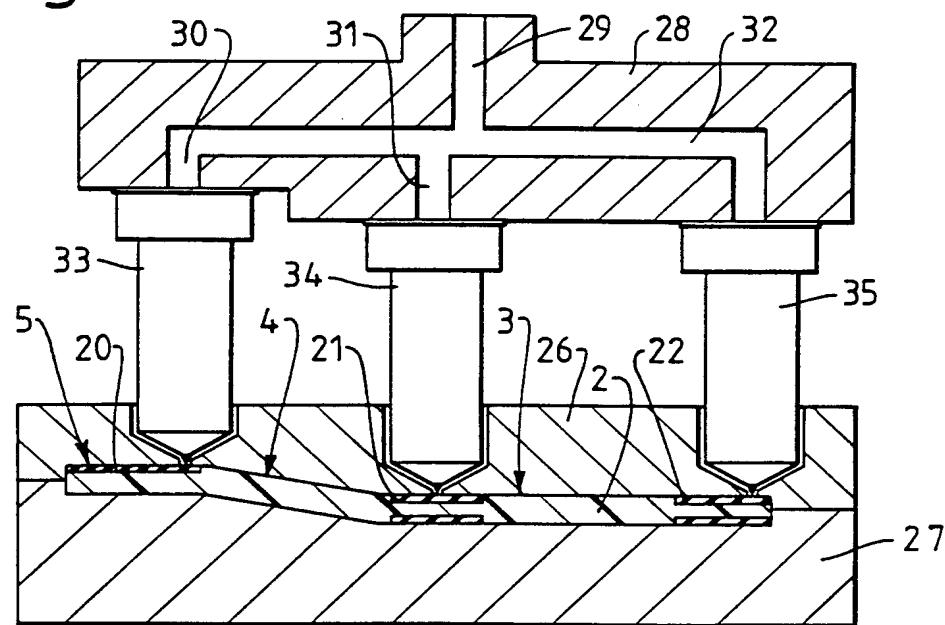


Fig. 3



SUBSTITUTE SHEET

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Fig.4*Fig.5*

INTERNATIONAL SEARCH REPORT

International application No.

PCT/NO 93/00132

A. CLASSIFICATION OF SUBJECT MATTER

IPC5: A46B 9/04, B29C 45/14

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC5: A46B, B29C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

DIALOG, EPOQUE

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US, A, 5054154 (SCHIFFER ET AL.), 8 October 1991 (08.10.91), column 2, line 30 - line 35; column 3, line 47 - line 58, figures 1-12 --	1-3,6,7
X	US, A, 5052071 (HALM), 1 October 1991 (01.10.91), column 4, line 56 - line 59	1-2
A	--	3-8
A	DE, U1, 9103553 (BOUCHERIE), 14 August 1991 (14.08.91), page 1, line 6 - line 17; page 7, line 10 - line 13 --	9

 Further documents are listed in the continuation of Box C. See patent family annex.

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Date of the actual completion of the international search

Date of mailing of the international search report

10 December 1993

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INTERNATIONAL SEARCH REPORT

International application No.

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C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, A, 3914081 (AOKI), 21 October 1975 (21.10.75), column 1, line 7 - line 14, abstract -- -----	9

INTERNATIONAL SEARCH REPORT
Information on patent family members

16/10/93

International application No.	
PCT/NO 93/00132	

Patent document cited in search report	Publication date	Patent family member(s)		Publication date
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US-A- 5052071	01/10/91	AU-A- BE-A- CH-A- DE-U- DE-U- EP-A,B- SE-T3-	3225189 1001285 679268 6890162 8903911 0336641 0336641	05/10/89 12/09/89 31/01/92 02/07/92 11/05/89 11/10/89
DE-U1- 9103553	14/08/91	NONE		
US-A- 3914081	21/10/75	CA-A- DE-A- FR-A- GB-A-	984565 2063850 2077576 1325614	02/03/76 01/07/71 29/10/71 08/08/73